



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3137-3
Job Sheet 169535



Part No: D3137-3

Job Qty: 40 ea

Part Name: Guide



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/13/17

Job Tracking No:

Due Date: 12/21/17

Created By: Linda Lacelle

Type: SOLD

Description:

Customer: Hevilift Logistics (CHLIFT01)

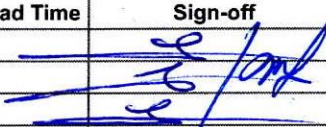
4/368 Earnshaw Road Checkpoint Business Park, Banyo Brisbane, Queensland, 4014 Australia ph:+61 7 36218319

Note: DWG REV F IPP Rev:A 02.05.29 New Issue NG IPP Rev:B 08-05-23 revE as per dwg DD verified by:EC IPP Rev c 08.07.03 ECN1207 EC verified by DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea	12/20/17	12/20/17	0.00	0.00	Start Up Machining-1		
100	Bandsaw	40 pcs	12/20/17	12/20/17	0.00	0.49	Bandsaw1		
110	CNC Vertical Machining	40 pcs	12/21/17	12/21/17	0.08	9.37	HAAS1-3		
130	QC	40 pcs	12/21/17	12/21/17	0.00	0.00	QC8 Machining-1		
140	Packaging	40 pcs	12/21/17	12/21/17	0.00	0.00	Packaging3-1		
150	QC21-SA	40 Ea	12/21/17	12/21/17	0.00	0.00	QC21		DAS 21 9-59 DEC 2 2017

Part Op 100 - Cut Blanks.Blank size: 1.250" x .750" x .950" long
Descriptions: 110 - 1-Machine as per Folio FA242 & Dwg D3137

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MDELRINB0.75X1.250	3	11	0	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE

QA Closed: _____ Date: _____

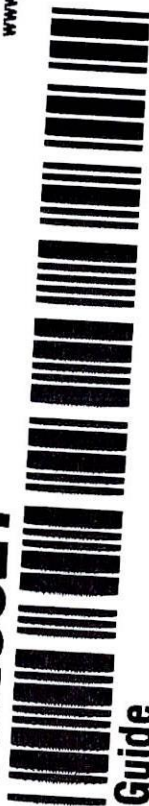
Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube Machining Thermoforming Large Fal
Part No. _____		
NCR No. _____		
Date : _____		
Step #: _____	QTY Effe	

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Hawkesbury, ON K64 1K7
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www.dartaerospace.com

Description Work Order Deviation

Root Cause <table> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>		Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	<table> <tr><td>☐</td><td>Pressure/Forced</td><td>☐</td><td>Temperature/</td></tr> <tr><td>☐</td><td>Bending</td><td>☐</td><td>Set-up</td></tr> <tr><td>☐</td><td>Centre Not Concentric</td><td>☐</td><td>BOM/Route</td></tr> <tr><td>☐</td><td>Cracks</td><td>☐</td><td>Broken/Dama</td></tr> <tr><td>☐</td><td>Crimp/Kink/Ripple/Wave</td><td>☐</td><td>Inspection Inc</td></tr> <tr><td>☐</td><td>Cuffs</td><td>☐</td><td>Contamination</td></tr> <tr><td>☐</td><td>Crushing</td><td>☐</td><td>Countersink</td></tr> <tr><td>☐</td><td>Heat Treat</td><td>☐</td><td>Cut Too Short</td></tr> <tr><td>☐</td><td>Wave/Twist in Tube</td><td>☐</td><td>Instructions Incomplete/Unclear</td></tr> <tr><td>☐</td><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td></tr> </table>	☐	Pressure/Forced	☐	Temperature/	☐	Bending	☐	Set-up	☐	Centre Not Concentric	☐	BOM/Route	☐	Cracks	☐	Broken/Dama	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Inc	☐	Cuffs	☐	Contamination	☐	Crushing	☐	Countersink	☐	Heat Treat	☐	Cut Too Short	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Marks/Chatter	☐	Drill Holes
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OTHER :																																																																																										

DART
AEROSPACE
S025327



D3137-3
Start up Operation
PART NO:
Revision:
Operation:
Change No:

Mfg Date: 12/19/17
Job No: 169535

Approval	By	Supervisor	Coordinator	Wrong
☐	☐	☐	☐	mensions
☐	☐	☐	☐	er tolerance
☐	☐	☐	☐	rect
☐	☐	☐	☐	Missing
☐	☐	☐	☐	ed
☐	☐	☐	☐	Drawing
☐	☐	☐	☐	Finish
☐	☐	☐	☐	Misread
☐	☐	☐	☐	Turning Sequence

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Guide	0.175inches $\pm$ 0.010	0.185 0.165		
2	Guide	0.257inches + 0.005 - 0.000	0.262 0.257		
3	Guide	0.650inches $\pm$ 0.010	0.660 0.640		
4	Guide	100Degrees $\pm$ 0	100 100		
5	Guide	0.425inches $\pm$ 0.010	0.435 0.415		
6	Guide	0.550inches $\pm$ 0.010	0.560 0.540		
7	Guide	1.100inches $\pm$ 0.010	1.110 1.090		
8	Guide	0.470inches $\pm$ 0.010	0.480 0.460		
9	Guide	0.850inches $\pm$ 0.010	0.860 0.840		
10	Guide	0.143inches $\pm$ 0.010	0.153 0.133		

Plex 12/13/17 12:48 PM dart.lacelle.linda

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
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Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

